

Work Order ID 134921-2 Split

134921

Page 1

Wednesday, July 22, 2015 4:16:22 PM

Item ID: D3694-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Mounting Plate

Start Date: 7/22/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/22/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: JUL 23 2015 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3694

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 7.150" long

7 6 SL 16-15

DAS

45

9-89

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA731 Rev: AP & Dwg D3694 Rev: C 2-Tap 10-32 heli-coil holes Manually 2-Deburr per dwg D3694

5 1

DAS

45

9-89

P.T.O.

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

5 1

DAS

45

9-89

2016-01-07

DQA: short Date: 16/01/07



QA Closed: RJM Date: 16/02/08

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>134921</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3694-1</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-5559</u>		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date: <u>16-01-11</u>	Step #: <u>100</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval
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Description Work Order Deviation 1 part, the thickness .125" $\pm$.030 was .120" and when removing tap in hole part came loose in vise P.C. part was not sitting flat in vise	Disposition Scrap & destroy. Replace <u>M. 129639 sty 16/01/11</u>	PD 16-01-11 DAS 45 Completed By J. 16-01-11 Lead hand / Supervisor Approval Verification L. 16/01/11 QC / QA Coordinator Approval PD 16-01-11
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☒	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☒		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					

Work Order ID 134921

134921

Page 2

Wednesday, July 22, 2015 4:16:22 PM

Item ID: D3694-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Plate

Start Date: 7/22/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/22/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				5	0		DAS 14 9-89 16/01/11
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per OSI005 4.1 Memo	0.00 0.00				5	0	11 14/01/11	
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 130746 Memo *****Mask all in surface as per Dwg D3694-1*****START TIME: 3:30 OVEN TEMPERATURE: 320° FINISH TIME: 4:20	0.00 0.00				5	0	16-01-11	DAS 34 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 134921

Wednesday, July 22, 2015 4:16:22 PM

134921

Page 3

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mounting Plate

Start Date: 7/22/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/22/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

JAN 12 2016

170

Identify as per dwg & Stock Location: ST50

0.00

170

Packaging

Memo

0.00

Packaging

JAN 13 2016

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

JAN 13 2016

JAN 13 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, July 22, 2015 4:16:21 PM

Page 1

Work Order ID: 134921

134921

Parent Item: D3694-1

D3694-1

Parent Item Name: Mounting Plate

Start Date: 7/22/15

Required Date: 7/22/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 09-01-13 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X06.00 0		Purchased	No				f	43.6790		0.630315			

M6061T6B1 000X06 000

**

6061T6 BAR 1.00 X 6.00

Location	Loc Qty	Loc Code
MAT003	43.679	
m125771 x?	2.4	
m127797	2.7	
m129530	2.15	
m129639 x 3 + x 1	18.2	
m130013	18.229	

1.8

2.2 + 9.604 ft

4.604 ft

DAS
45 2016-01-08
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 134921
Description: Keyway		Part Number: D3694-1
Inspection Dwg: D3694	Rev: C	Page 1 of 1

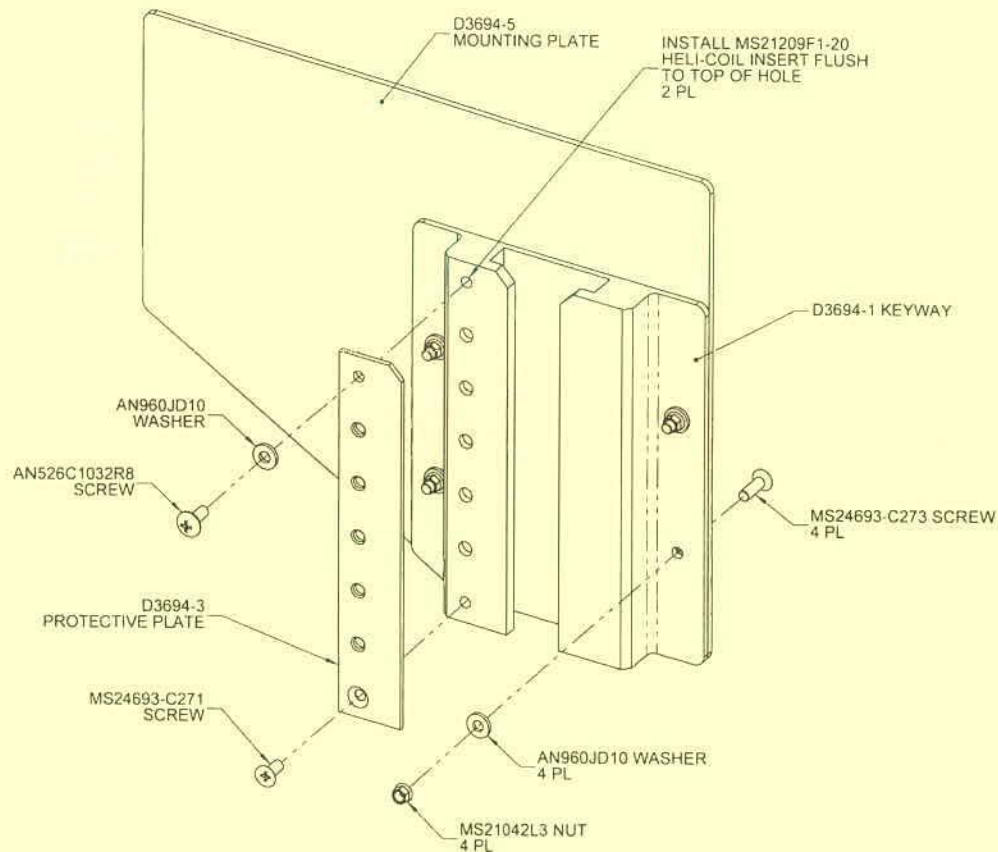
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	0.205	✓		caliper	JTC-01
0.673 deep	+/-0.010	0.669	✓		"	"
Ø0.257	+0.006/-0.001	0.259	✓		"	"
0.200 deep	+/-0.010	0.199	✓		"	"
6.75	+/-0.030	6.747	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
4.000	+/-0.010	4.000	✓		"	"
1.000 pitch	+/-0.010	1.000	✓		"	"
0.375	+/-0.010	0.376	✓		"	"
4.114	+/-0.010	4.113	✓		HU	31006
1.375	+/-0.010	1.373	✓		caliper	JTC-01
2.000	+/-0.010	1.998	✓		"	"
2.500	+/-0.010	2.499	✓		"	"
Ø0.204	+0.005/-0.001	0.206	✓		"	"
0.500	+/-0.010	0.499	✓		"	"
4.602	+/-0.010	4.604	✓		"	"
1.000	+0.010/-0.000	1.004	✓		cal + pin	JTC-01 + Shop
0.13 x 45°	+/-0.030 x 0.5°	0.130 x 45°	✓		depth G + pin	JTC-07 + Shop
R0.13	+/-0.030	0.125	✓		read G	Shop
0.88	+/-0.030	0.885	✓		micrometer	JTC-02
0.125	+0.030/-0.000	0.142	✓		"	"
5.60	+/-0.030	5.60	✓		caliper	JTC-01
3.60	+/-0.030	3.603	✓		"	"
2.020	+0.050/-0.000	2.027	✓		"	"
0.505	+0.000/-0.005	0.503	✓		"	"
1.0	+/-0.030	0.999	✓		HU	31006
1.791	+/-0.010	1.785	✓		"	"
2.301	+/-0.010	2.297	✓		"	"

Measured by: DAS 45 9-89	Audited by: DAS 14 9-89	Prototype Approval:	N/A
Date: 2016-01-07	Date: 16/01/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	



D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

134921 MJS
15-07-23

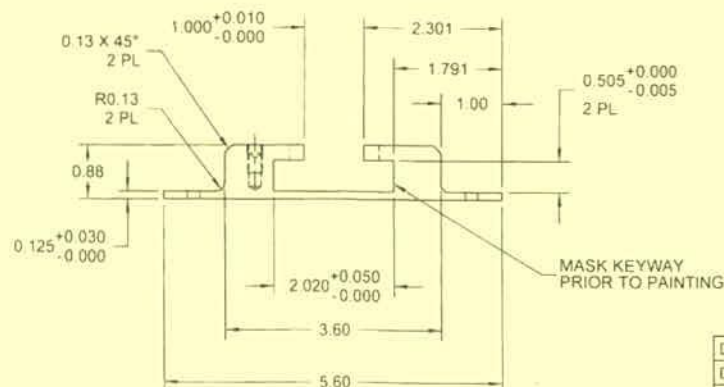
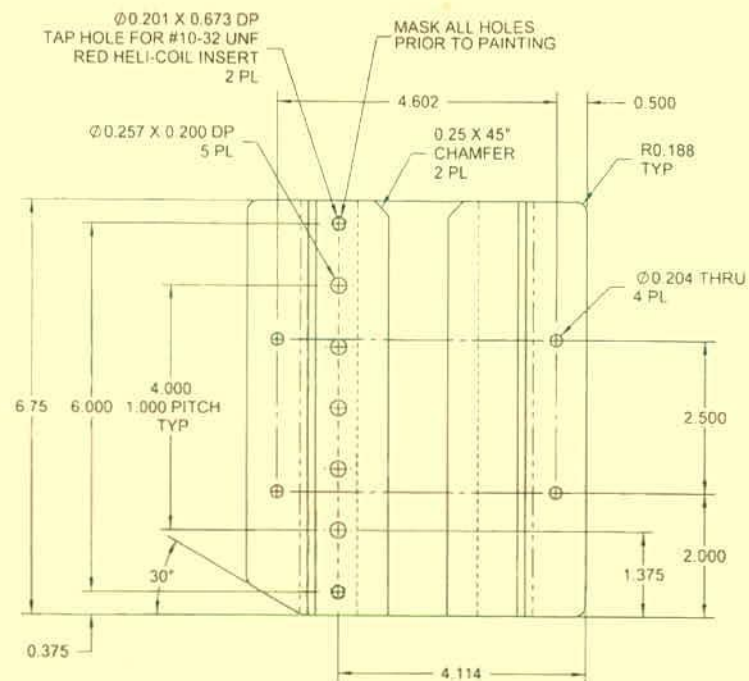
RELEASED
09/05/14

C	REDESIGNED ITEM 11, REVISED ITEM 12, DIM Ø0.204 WAS Ø0.234 (ZN D6-3), ADDED ITEM 13, UPDATED BOM TO CURRENT STANDARDS (ZN D3-1) REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY 2 (ZN D3-1), ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1), 1.18 WAS 1.15 (ZN C7-3), CSK WAS 2 PL (ZN D4-3), 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3694
TITLE
MOUNTING PLATE ASSY
REV. C
SHEET 1 OF 4
SCALE
NTS

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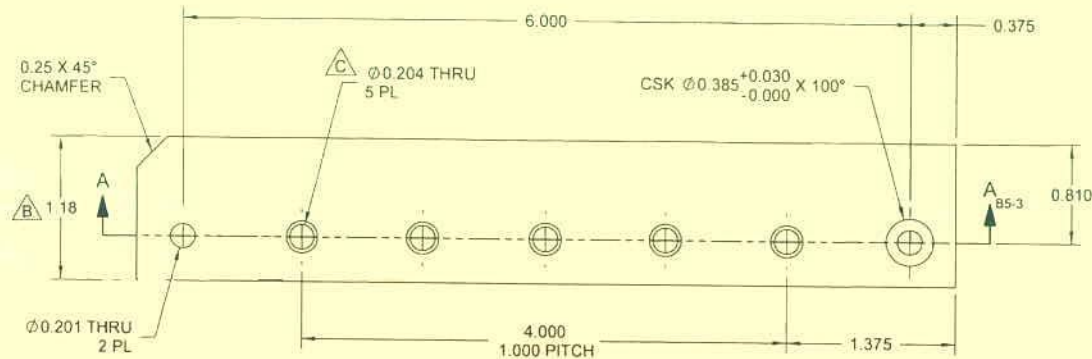
D3694-1 KEYWAY

D3694-1 NOTES:

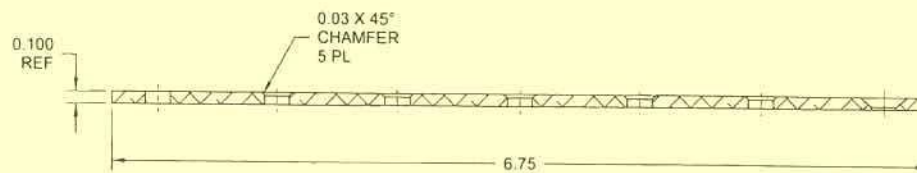
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

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02/05/10

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CHECKED		DRAWING NO.	REV. C
MFG APPR		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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D3694-3 PROTECTIVE PLATE



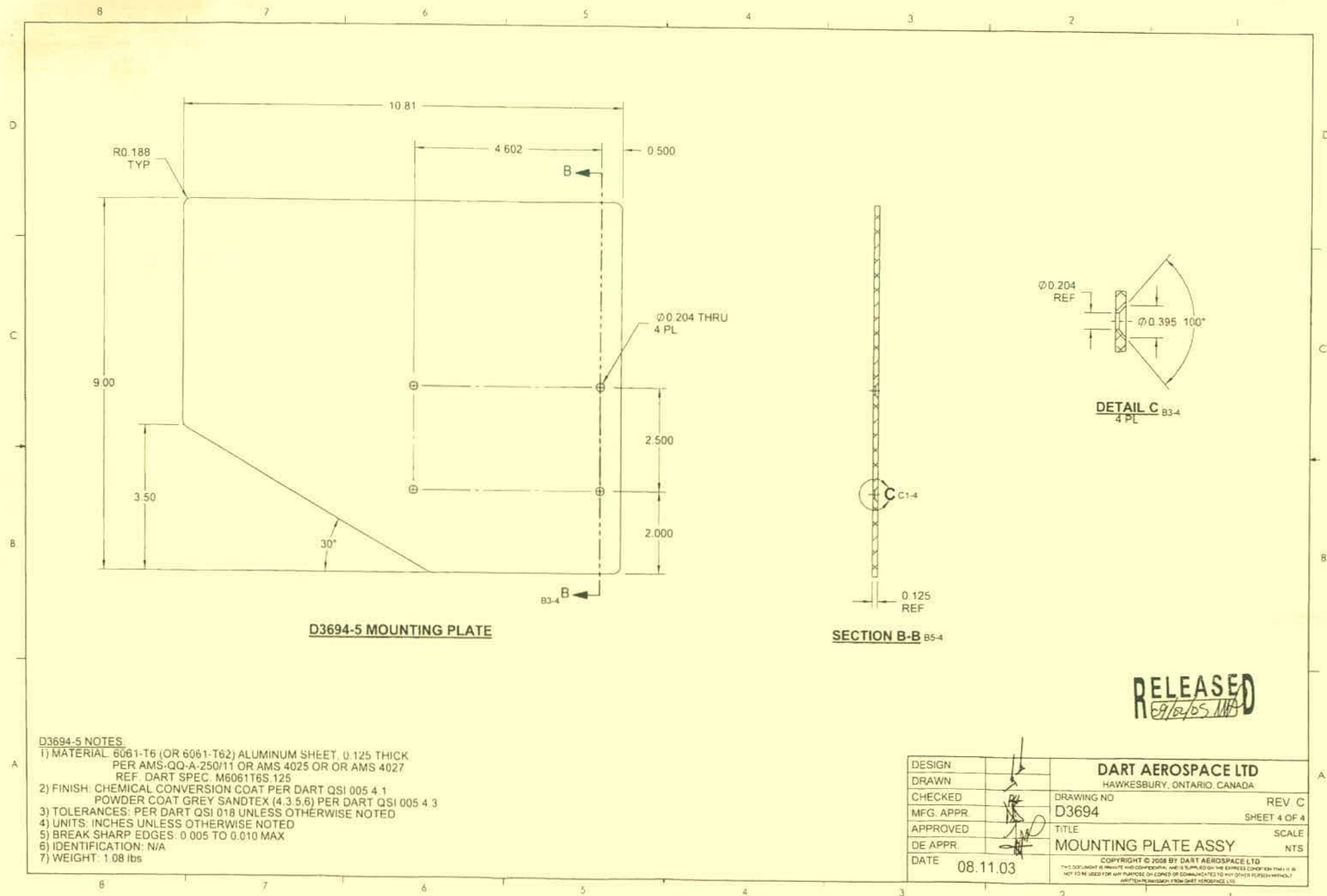
SECTION A-A-C3-3

D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF: DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

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D3694-5 MOUNTING PLATE

SECTION B-B B5-4

DETAIL C B3-4

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D3694-5 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

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DE APPR.		MOUNTING PLATE ASSY	NTS
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